Interfine® 3399

Fluorocarbon

PRODUCT DESCRIPTION

A high performance, two component, fluorocarbon finish which affords extended lifetime to first maintenance when utilised as part of a high performance anti-corrosive system. Interfine 3399 offers superior gloss and colour retention and provides significantly improved resistance to yellowing and chalking when compared to typical conventional topcoats including catalysed acrylic, and polyurethane finishes.

INTENDED USES

For use in those market sectors where a high standard of cosmetic appearance is a key requirement. Those markets include bridges, sport stadia, offshore platforms, tank farms, chemical and petrochemical plants, pulp and paper mills, and the power industry, in addition to general industrial and commercial steelwork where aesthetics are important.

PRACTICAL INFORMATION FOR INTERFINE 3399

Colour	Clear, Metallic and a selected range of colours
Gloss Level	Gloss
Volume Solids	48% ± 3%
Typical Thickness	40-60 microns (1.6-2.4 mils) dry equivalent to 83-125 microns (3.3-5 mils) wet
Theoretical Coverage	9.60 m²/litre at 50 microns d.f.t and stated volume solids 385 sq.ft/US gallon at 2 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Air spray, Brush

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	1 hour	45 hours	45 hours	2 weeks
15°C (59°F)	30 minutes	20 hours	20 hours	2 weeks
25°C (77°F)	30 minutes	11 hours	11 hours	2 weeks
40°C (104°F)	30 minutes	4 hours	4 hours	2 weeks

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 29°C (84°F); Mixed 27°C (81°F)	
Product Weight	1.25 kg/l (10.4 lb/gal)	
VOC	3.98 lb/gal (477 g/lt) 446 g/lt	EPA Method 24 Chinese National Standard GB23985

Coating hazard marker GB 30981.2-S-Pb≤90-C Qualified for GB 30981.2-2025

See Product Characteristics section for further details

Fluorocarbon

SURFACE PREPARATION

All surfaces must be clean, dry, and free of oil, grease, dust, and other contaminations. To ensure the best appearance, the primer or undercoat should be smooth and free of any surface defects, such as runs, dry spray or heavy orange peel. Prior to paint application, all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Primed Surfaces

Interfine 3399 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interfine 3399 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interfine 3399.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

(1) Agitate Base (Part A) with a power agitator.

(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

It is recommended that Interfine 3399 is allowed a 15 minute induction period after mixing, prior to commencing application.

Mix Ratio

5.5 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
6.5 hours	4 hours	3 hours	1.5 hours

Airless Spray	Recommended	Tip Range 0.43-0.48 mm (17-19 thou) Total output fluid pressure at spray tip not less than 155 kg/cm² (2204 p.s.i.)
Air Spray (Pressure Pot)	Recommended	Gun DeVilbiss MBC or JGA Air Cap 704 or 765 Fluid Tip E
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment
Brush	Suitable - Touch up and small areas only	Typically 25-50 microns (1.0-2.0 mils) can be achieved
Roller	Not recommended	
Thinner	International GTA263	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.
Cleaner	International GTA263	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA263. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA263. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

It is recommended that Interfine 3399 is allowed a 15 to 30 minute induction period after mixing, prior to commencing application.

When using metallic finishes, a single method of application should be used whenever possible, as different application methods will give varying aesthetic effects.

When overcoating after weathering or ageing, ensure the coating is fully cleaned to remove all surface contamination such as oil, grease, salt crystals and traffic fumes, before application of a further coat of Interfine 3399.

This product must only be thinned using the recommended International thinners. The use of alternative thinners, particularly those containing alcohols, can severely affect the curing mechanism of the coating.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

When applying Interfine 3399 in confined spaces ensure adequate ventilation.

Condensation occurring during or immediately after application may result in an inferior film.

This product is not recommended for use in immersion conditions. When severe chemical or solvent splashing is likely to occur contact International Protective Coatings for information regarding suitability.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Interfine 3399 can be applied directly over the following approved products:

Interfine 878	Interfine 979
Intergard 251	Intergard 269
Intergard 475HS	Interseal 670HS
Interthane 870	Interthane 990
Interzone 954	

For other suitable undercoats, consult International Protective Coatings.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

Warning: Contains isocyanate. Wear air-fed hood for spray application.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16.92 litre	20 litre	3.08 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	22.8 kg	3.71 kg

STORAGE	Shelf Life	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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